



CITGO AUTOKUT® AS SERIES

Date 11/10

DESCRIPTION: CITGO Autokut AS Series of transparent metal removing oils are highly active and do not contain chlorinated components. Fluids in this group are formulated for machining operations involving alloyed, stainless and chrome steels. These products are intended for the most severe machining operations such as broaching, tapping and cold-heading. They contain a mist suppressant to aid in meeting OSHA requirements.

QUALITIES: CITGO Autokut AS 15 is a low viscosity, light colored, heavy-duty oil with additive treatment to provide a high degree of anti-weld capability.

CITGO Autokut AS 32 is a light colored, heavy-duty fluid formulated to accommodate the most severe applications with respect to operation and metallurgy. The elevated amount of lubricity additive allows excellent surface finish at high feeds and speeds.

CITGO Autokut AS 46 is a light colored, heavy-duty fluid designed for severe duty applications. The elevated amount of lubricity additive allows excellent surface finish and the higher level of sulfur provides excellent anti-weld capability.

CITGO Autokut AS 68 is a light colored, heavy-duty formulation for the most severe applications. A high level of lubricity additive permits excellent surface finish and the very high level of sulfur provides a very high degree of anti-weld capability.

NOTE: Since all of these fluids contain active sulfur, they should not be used with copper, aluminum, or other non-ferrous alloys.

TYPICAL PROPERTIES:

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Grade	AS 15	AS 32	AS 46	AS 68
Material Code	639430001	639432001	639433001	639434001
Gravity, ASTM D 4052, °API	33.6	31.1	29.7	28.2
Gravity, Specific, ASTM D 1298, 60/60°F	0.857	0.870	0.878	0.886
Density, lb/gal	7.2	7.3	7.3	7.4
Flash Point, COC, ASTM D 92, °F (°C)	349 (176)	363 (184)	356 (180)	356 (180)
Viscosity, cSt at 40°C	16.6	30.7	45.5	65.4
cSt at 100°C	3.8	5.6	7.1	8.9
SUS at 100°F	89	158	245	338
SUS at 210°F	39	45	50	56
Color, ASTM D 1500	1.0	1.5	1.5	1.5
Pour Point, ASTM D 97, °F (°C)	-45.4 (-43)	-22 (-30)	-14.8 (-26)	-14.8 (-26)
Copper Corrosion, ASTM D 130, 3 hrs at 212°	4	4	4	4
Active Sulfur	Yes	Yes	Yes	Yes
Phosphorus	Yes	Yes	Yes	Yes
Lubricity Additive	Yes	Yes	Yes	Yes